

5/44

DART AEROSPACE LTD	Work Order:	24507
Description: Plate	Part Number:	D3219-1
Dwg: D3219 Rev. A	Qty:	206100
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: To be made in multiples of 4	<i>[Signature]</i>	05.10.12	100
2	MV	(1) blank makes (2) D3219-1 Cut blanks: 4.350" x 3.200" Material: 6061-T6 (QQ-A-200/11) 0.125" thick (M6061T6S.125) Identify for D3219-1 Batch: <u>M18666</u>	J.G	05/10/31	200 100
3	MV	Machine as per Folio FA403 and Dwg D3219 Stack of 4 Identify as D3219-1	J.L	05.11.03	200
4	QC2	Inspect parts as they come off the CNC machine	J.L	05.11.03	200
5	QC8	Second check	<i>[Signature]</i>	05/11/03	200
6	GA	Deburr & <i>REMOVE ANY MARKS ON MATERIAL</i>	<i>[Signature]</i>	05/11/06	200
7	QC6	Inspect work to Step 6	<i>[Signature]</i>	05/11/13	200
8	ST	Identify and Stock	<i>[Signature]</i>	05.11.14	200
9	AC	Cost / part <u>1.88</u>	<i>[Signature]</i>	05.11.19	200
10	DC	Close W/O <u>2.35</u> Inspect Level 21	<i>[Signature]</i>	05/11/18	200

Rev	Date	Change	Revised By	Approved
A	04.04.19	New issue	KJ/JLM	<i>[Signature]</i> 04.04.22

RELEASED

04.04.22

04.04.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

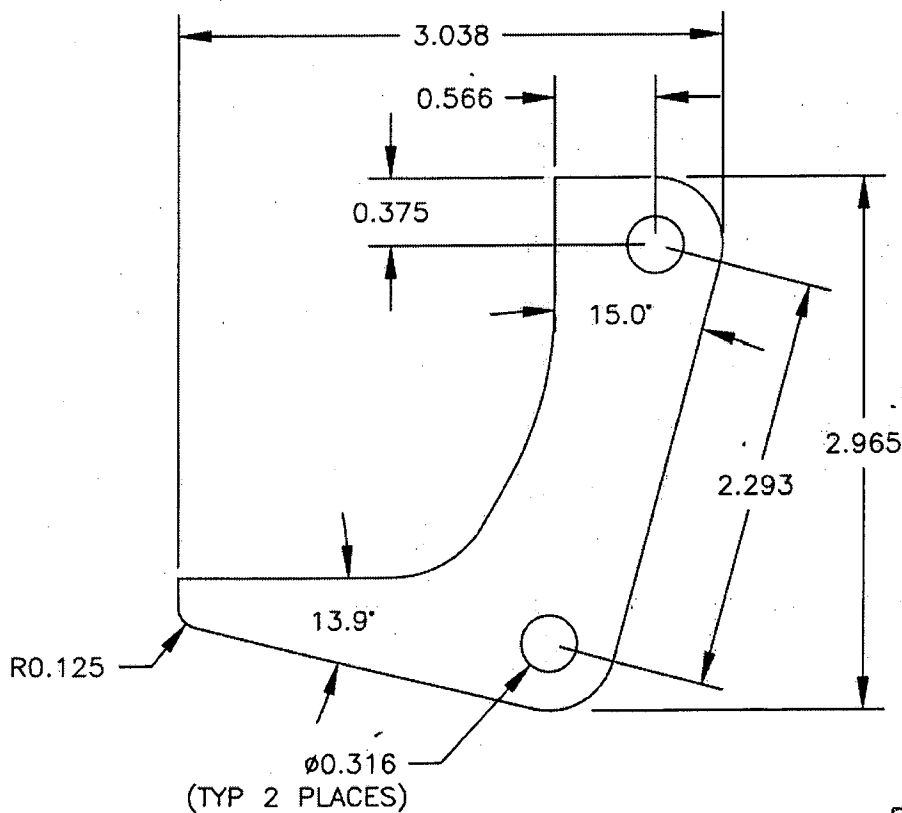
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3219	REV. A SHEET 1 OF 1
DATE 03.10.10		TITLE PLATE	SCALE 1:1
A	03.10.10	NEW ISSUE	

RELEASED
04.04.05



D3219-1 PLATE

- 1) MACHINE PER DWG FILE "D3219-1.SLDPR1"
- 2) MATERIAL: 6061-T6, 0.125 THICK (QQ-A-250/11)
(REF DART SPEC M6061T6S.125)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
ST T
WITHOUT
WORK ORDER
NO. 24507

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 11, 2005
07:41 am

Work Order No : 0024507
Project Name : D3219-1
Project For : WK544
Work Order Type : Main
Main WO Number :
House Part Number : D3219-1
Description : Support
Manufactured : Yes
Amount Req'd : 100
Amount Done : 0
Start Date : 10-08-05
Est Finish Date : 11-05-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
12:21 pm

Work Order No : 0024507
Project Name : D3219-1
Project For : WK544
Work Order Type : Main
Main WO Number :
House Part Number : D3219-1
Description : Support
Manufactured : Yes
Amount Req'd : 100
Amount Done : 0
Start Date : 10-08-05
Est Finish Date : 11-05-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	11.50	100.00		
Production Cost :	0.00	189.77	100.00	0.00	189.77
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	10.00	100.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	189.77	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	189.77			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	(-189.77)

MIS J/B
11-13

Date: Monday, 14/11/2005 8:13:12 AM
 User: Alba Panzuto

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	PLATE
Job Number :	24507		
Estimate Number :	10425		
P.O. Number :		Part Number :	D32191
This Issue :	14/11/2005	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3219 REV A
First Issue :	//	Project Number :	
Previous Run :		Drawing Revision :	A
	Type :	Material :	
	MACHINED PARTS	Due Date :	30/11/2005
Written By :		Qty:	100
Checked & Approved By :		Um:	Each
Comment :	Est. A04.04.19 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S125	6061-T6 .125 Sheet
2.0	SHEAR	SHEAR
Comment: SHEAR Cut blanks: 4.350" x 3.200" Machine as per Folio FA403 and Dwg D3219 Stack of 4 Identify for D3219-1		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr and remove any marks on material		
6.0	QC6	DIMENSIONAL CHECK
Comment: DIMENSIONAL CHECK		

Date: Monday, 14/11/2005 8:13:12 AM
User: Alba Panzuto

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 24507

Part Number: D32191

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

